

Date: Tuesday, 22/04/2008 3:53:23 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 38756	
Estimate Number : 12322	
P.O. Number :	Part Number : D3492041
This Issue : 22/04/2008 S.O. No. :	Drawing Number : D3492 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 38562	Material :
Written By :	Due Date : 15/05/2008 Qty: 100 Um: Each
Checked & Approved By : <u>JLD 08.4.23</u>	
Comment : est rev A 06.03.03 New Issue EC	
Est Rev:B 06-08-28 As per Rev B JLM	
Est Rev:C 07-12-06 Rev C dwg DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0656 f(s)/Unit Total : 6.5625 f(s)
 6061-T6 Round Bar .625"
 (M6061T6R0625)
 Batch: 107513

MMF 08/04/28 DD

119

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA633 & Dwg D3492
 Dwg Rev: B
 Folio Rev: AA

DD MMF 08/04/28

119

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MMF 08/04/28 DD

119

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

MMF 08/04/28

119

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if neccesay

MMF 08/04/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:53:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 38756

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/04/2

(119)

B38756

30 D3492041

S.162 14.19

#1 323.3 F

#2 30 F

#3 --- F

#4 --- F

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Flat End Only)

HP 08.04.30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/04/30

(119X)

9.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-010 O-RING

(or MS28775-010)

M100539 BR/R1708/05/01

(119)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

1- Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch:

M101223 BR/R1708/05/01

(119)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

QSP09 S 08/05/01 (X109)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FP-1 M-L 08/05/01

(119X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:53:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 38756

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/05 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

08-05-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38756
Description: Plug		Part Number: D3492-1
Inspection Dwg: D3492	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

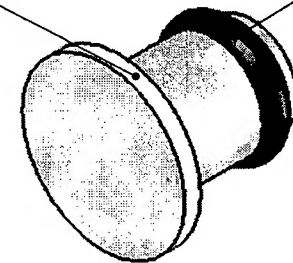
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	0.060	✓			
0.060	+/-0.005	0.060	✓			
Ø0.394	+/-0.010	Ø0.392	✓			
Ø0.625	+/-0.010	Ø0.624	✓			
0.090	+0.000/-0.002	0.089	✓			
0.500	+/-0.010	0.499	✓			
0.055	+0.000/-0.002	0.056	✓			

Measured by: mmf/ank	Audited by: EC	Prototype Approval:	N/A
Date: 08/04/20	Date: 08-04-20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
B	06.10.16	Ø0.625 was Ø0.500	KJ/JLM	
C	07.11.23	Tolerances revised	KJ/EC/DD	

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ C △ C △ C

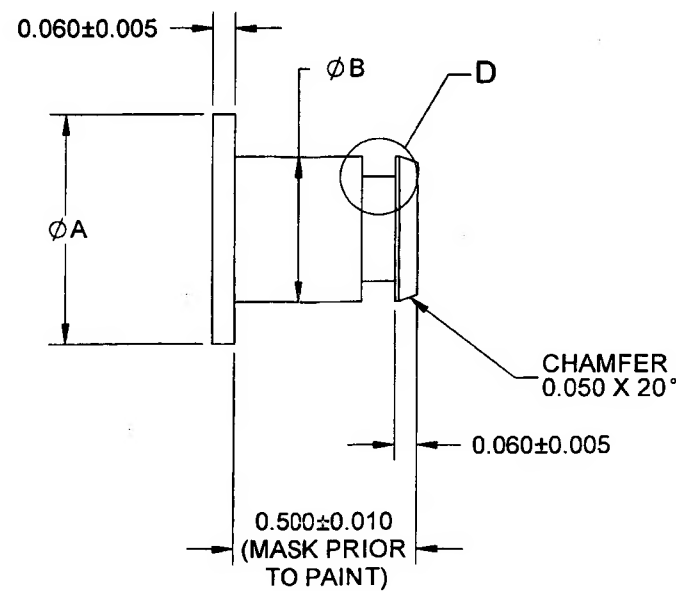
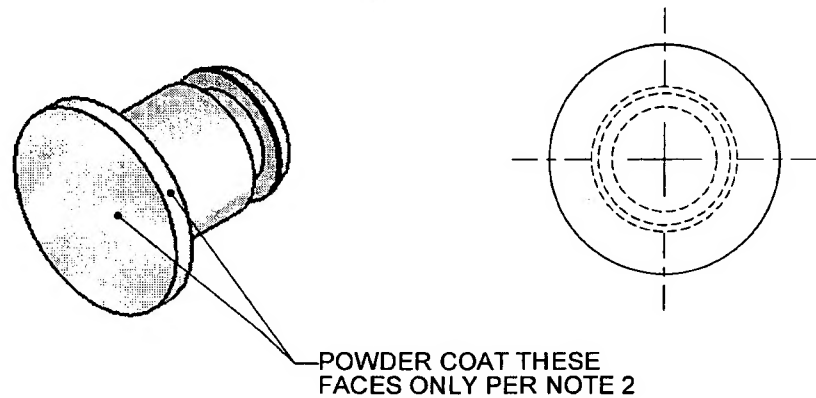
NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38756

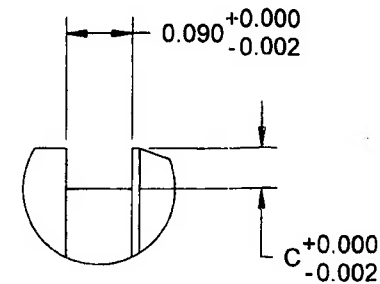
PH 05.04.23
UNDER REVIEW
01.04.21 PH
DIM 46 ON D3492-13
REST OK (MAKE SMALLER)

RELEASED
07.10.16

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3492	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	PLUG	2:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38756

Rev 01.04.23
UNDER REVIEW
01.04.23
DIM OK ON D3492-13
REV. OK (THREE SMALLER)

RELEASED
07.11.76

DESIGN	<i>Rev</i>	DART AEROSPACE LTD	
DRAWN	<i>Rev</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Rev</i>	DRAWING NO. D3492	REV. C
MFG. APPR.	<i>Rev</i>	SHEET 2 OF 2	
APPROVED	<i>Rev</i>	TITLE PLUG	SCALE 4:1
DE APPR.	<i>Rev</i>	DATE 07.10.05	
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